

Work Order ID 67603

Monday, March 28, 2011 2:27:49 PM



Page 1

Item ID:	D3290-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Replacement Window Assembly					
Start Date:	3/28/2011	Start Qty:	6.00		Cust Item ID:	
Required Date:	3/31/2011	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-03-20	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3290	DEO Rev C1								

100		0.00							
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	FLOW WATER JET								
Waterjet	Memo	0.00							

FLOW CNC Waterjet	1-Cut as per Dwg D3290 (use prog. for D3290-1)								
6061. 063	Dwg Rev: <u>C</u>								
	Prog Rev: <u>C</u>								
	2-Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

QC	Memo	0.00							

Quality Control									
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120	QC8- Inspect parts - second check	0.00							
-----	-----------------------------------	------	--	--	--	--	--	--	--

QC	Memo	0.00							

Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

B11-3-30

B11-3-30

x7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3290-041

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Setup Start



Revision ID:

Stop



Item Name: Replacement Window Assembly

Start Date: 3/28/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				7	BL	11-3-31	
Hand Finishing	Memo	0.00							
140 Powdercoat	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				7	BL	11-3-31	
Powder Coating	Memo START TIME: 1:05 OVEN TEMPERATURE: 320° FINISH TIME: 1:05	0.00 3:30 3:30 4:00							
150 QC	QC3- Inspect Part Finish	0.00				7	φ	11/03/31	
Quality Control	Memo	0.00							

Dart Aerospace Ltd

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Page 3

Item ID: D3290-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Window Assembly

Start Date: 3/28/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Small Fab	Small Fab	0.00				(X) 5			11/04/20
Small Fab	Memo	0.00				51			
Small Fab	Assemble as per Dwg D3290 Clean D3290-041 and place in plastic wrap								
170 QC	QC5- Inspect part completeness to step on W/O	0.00				(9)			
Quality Control	Memo	0.00							
180 Packaging	Identify as per dwg & Stock Location: <u>51219</u>	0.00							
Packaging	Memo	0.00							11/4/20

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Picklist Print

Monday, March 28, 2011 2:27:55 PM

Page 1

Work Order ID: 67603

Parent Item: D3290-041

Parent Item Name: Replacement Window Assembly


Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B05.05.25 Added Step 11 KJ/JLM
IPP C06.05.09 Ecn 798 EC
IPP Rev:D Now on Waterjet 06-06-16 JLM
IPP rev E rev C dwg 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063  6061-T6 .063 Sheet		Purchased	No			100	sf	63.0000	3.75	23.68421	27.		

HB 11-3-30

Location	Loc Qty	Loc Code
MAT021	63	
113608	5	
116308	38	
116623	20	


⑦

D2126  Seal		Manufactured	No			160	f	341.0000	6.5	39			
--	--	--------------	----	--	--	-----	---	----------	-----	----	--	--	--

Location	Loc Qty	Loc Code
ST405	341	
57106	4	
64918	337	

11/04/20

(D2126-0780) cut qty (1) at 78.00" as per dwg
per kit

D3290-3  Window		Manufactured	No			160	Each	0.0000	1				
--	--	--------------	----	--	--	-----	------	--------	---	--	--	--	--

B67602

6
x 7

11/04/20

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	<i>Q7603</i>
Description: Window Frame		Part Number:	D3290-1
Inspection Dwg: D3290 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	<i>29.00</i>	<i>x</i>		<i>T RB01</i>	
14.00	+/-0.030	<i>14.00</i>	<i>x</i>		<i>T</i>	
Ø0.171	+0.005/-0.001	<i>0.173</i>	<i>x</i>		<i>V RB02</i>	
1.50	+/-0.030	<i>1.511</i>	<i>x</i>		<i>V</i>	
1.11	+/-0.030	<i>1.109</i>	<i>x</i>		<i>V</i>	
10.10	+/-0.030	<i>10.10</i>	<i>x</i>		<i>T</i>	
18.50	+/-0.030	<i>18.50</i>	<i>x</i>		<i>T</i>	
0.063	+/-0.010	<i>0.064</i>	<i>x</i>		<i>V</i>	
R3.00	+/-0.030	<i>3.00</i>	<i>x</i>		<i>R.G.</i>	
R4.50	+/-0.030	<i>4.50</i>	<i>x</i>		<i>R.G.</i>	
Ø0.257	+0.006/-0.001	<i>0.257</i>	<i>x</i>		<i>V</i>	
13.61	+/-0.030	<i>13.61</i>	<i>x</i>		<i>T</i>	

Measured by: <i>B</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: <i>11-3-30</i>	Date: <i>11/03/30</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue P/O D3290-041	KJ/JLM	
B	07.07.18	13.61 dimension removed	KJ/JLM	
C	07.09.28	Dimensions update per Dwg Rev C	KJ/EC/DD	
D	09.11.04	Dimension 0.063 was 0.040	KJ	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

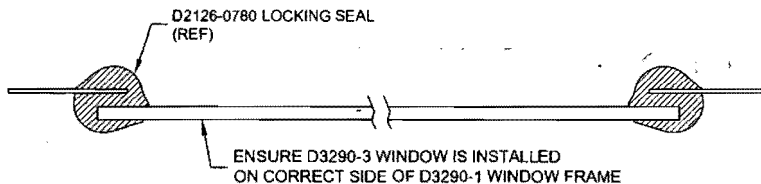
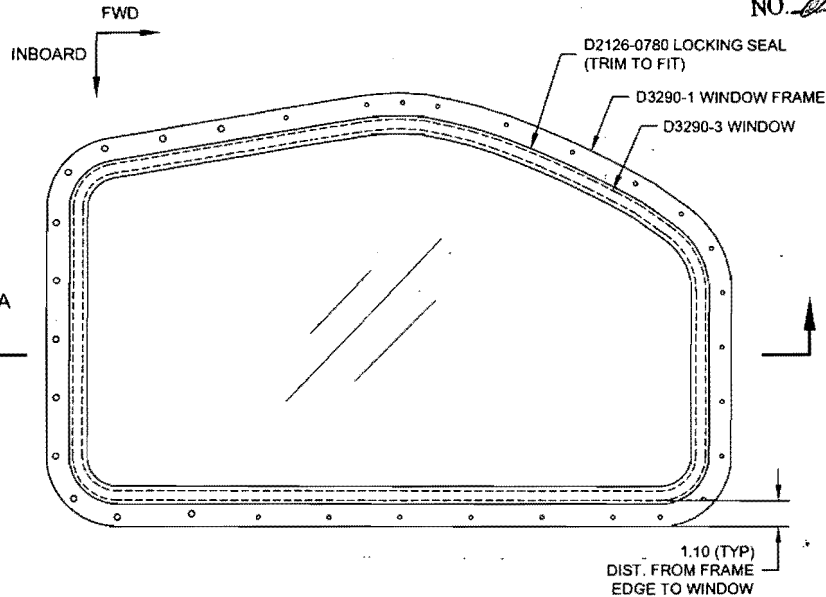
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. *67163*
PL1140328

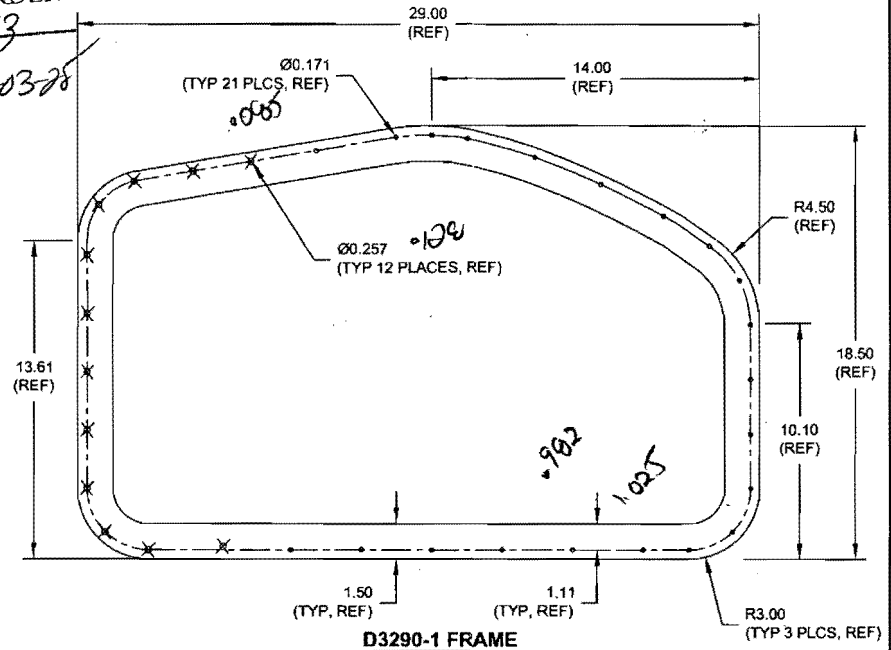


SECTION A-A
NTS

D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
2) UNITS: INCHES UNLESS OTHERWISE NOTED



D3290-1 FRAME

D3290-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
OR
5052-H32 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS

RELEASED
07.07.24
DEO ATTACHED

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3290 TITLE REPLACEMENT WINDOW ASSEMBLY SCALE 1:5 <small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN	<i>DC</i>		
CHECKED	<i>DC</i>		
MFG. APPR.	<i>DC</i>		
APPROVED	<i>DC</i>		
DE APPR.	<i>DC</i>		
DATE	07.07.24		

UNDER REVIEW

4/07.07.18
MIR 07-057
6/12/19

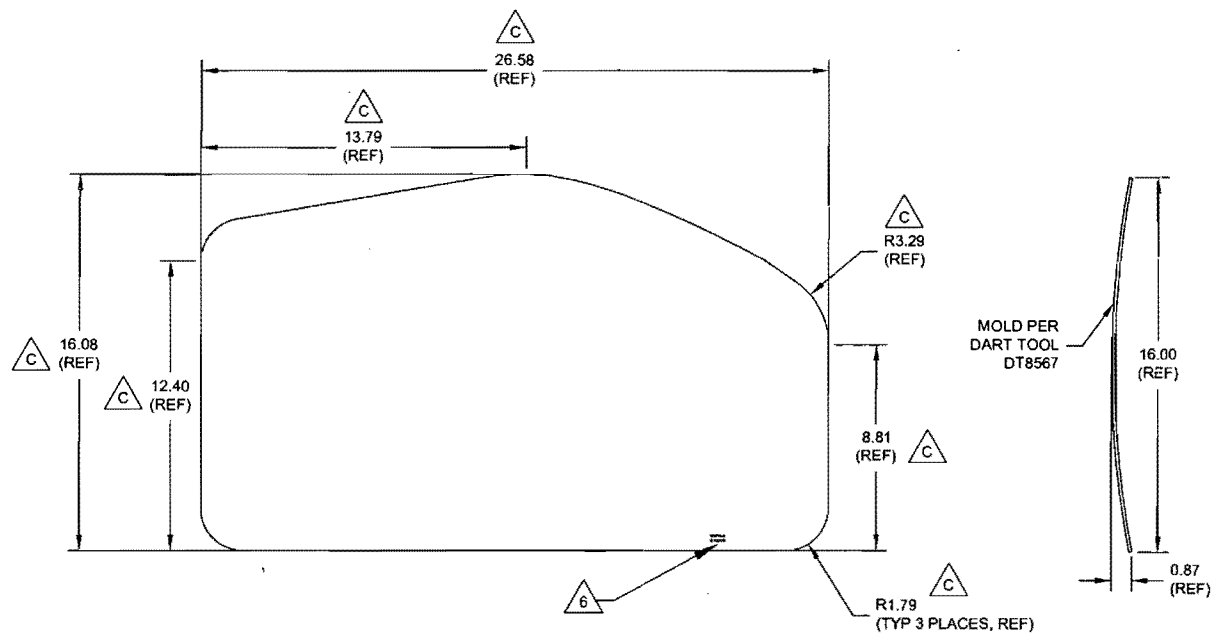
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NOTE: Date & initial all entries



D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

DESIGN	3	DART AEROSPACE LTD	
DRAWN	DE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DE	DRAWING NO.	REV. C
MFG. APPR.	DE	D3290	SHEET 2 OF 2
APPROVED	DE	TITLE	SCALE
DE APPR.	DE	REPLACEMENT WINDOW ASSEMBLY 1:5	
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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UNDER REVIEW

DEO ATTACHED

RELEASED

07.07.22

W067603

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>h</i>	MFG. APPR. <i>EZ</i>	APPROVED <i>AD</i>		DE APPR. <i>h</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

u10a7603

RELEASED
 2009-10-09
WMP

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